

Quality Control

F.K. 12/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81808

81808

Page 2

March-19-12 1:35:40 PM

Item ID: D2939-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 19/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 18/05/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		2L 12-04-25					
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							(8) 12-4-24
155 *155* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PRIME B 117319 DELFLEET BLUE B 121149 CLEAR DELFLEET B 118093	0.00 0.00							(8) 12-5-1 (8)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC14- Inspect Spray Paint	0.00							
165									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>Y21</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/05/04
 MLJ 12/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-19-12 1:35:46 PM

Work Order ID: 81808

81808

Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	53.0000	1	8			

D6101-001

**

Saddle Billet

Location	Loc Qty	Loc Code
MAT040	3	
69677	2	
76836	1	
MAT041	50	
80764	50	
81923		

8

F.B 12/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81808
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.115	.115	.115	.115	.115
B	0.100	0.140		.115	.115	.115	.115	.115
C	0.100	0.140		.120	.121	.121	.120	.121
D	0.210	0.230		.220	.220	.220	.221	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.122	.122	.122	.122	.122
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.498	.497	.497	.497
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.742	2.742	2.742	2.742	2.742
S	0.240	0.270		.251	.251	.251	.252	.251
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.260	1.260	1.260	1.260	1.260
Y	1.565	1.585		1.574	1.574	1.574	1.574	1.574
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: F.K.	Date: 12/04/24
Audited by: J	Date: 12-04-25
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

Dart Aerospace Ltd

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DART AEROSPACE LTD				Work Order: 21808	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

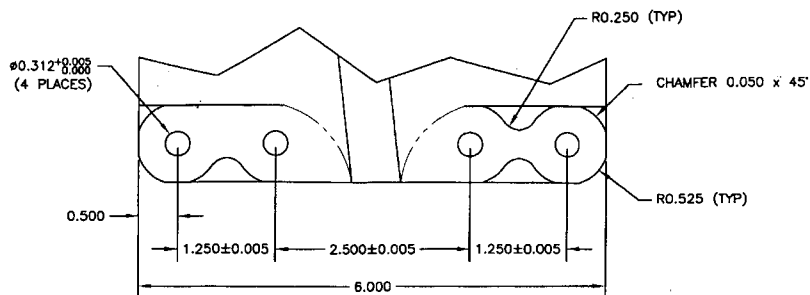
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 1	7 2	8 3	4	5
A	0.100	0.140		.115	.116	.115		
B	0.100	0.140		.115	.116	.116		
C	0.100	0.140		.121	.121	.121		
D	0.210	0.230		.220	.221	.221		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577		
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K	0.257	0.262		.258	.258	.258		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.236	.236	.236		
N	0.100	0.140		.122	.122	.123		
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P	0.490	0.510		.497	.497	.498		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742		
S	0.240	0.270		.251	.252	.252		
T	0.100	0.180		.135	.135	.135		
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W	0.316	0.321		.316	.316	.316		
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Y	1.565	1.585		1.573	1.573	1.574		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
Accept/Reject								

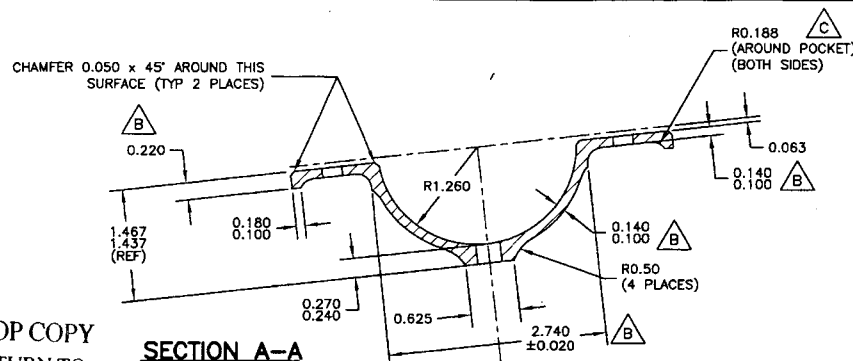
Measured by: FK	Date: 12/04/25
Audited by: SL	Date: 12-04-25
Prototype Approval: N/A	Date: N/A

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D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



VIEW C-C

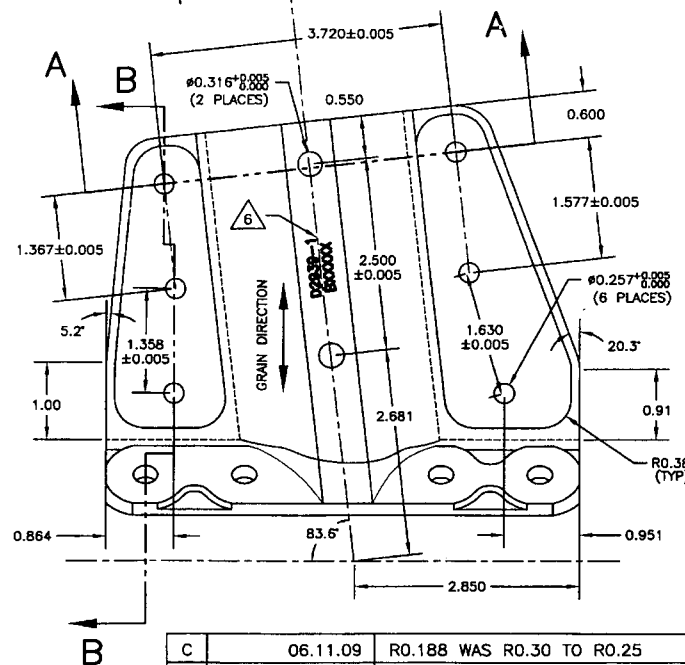
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81808 MJS
12/03/19



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SECTION B-B

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

D2939

SADDLE INSIDE

REV. C
SHEET 1 OF 1
SCALE
2:3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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